

Date: Thursday, 04/01/2007 11:43:40 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ROUND BILLET, ALUMINUM
<b>Job Number</b> : 30170	
<b>Estimate Number</b> : 12286	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D6103003
<b>This Issue</b> : 04/01/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D6103 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 28336	<b>Material</b> : N/A
<b>Written By</b> : _____	<b>Due Date</b> : 12/01/2007 <b>Qty:</b> 40 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : _____	
<b>Comment</b> : Est Rev:A New Issue 06-02-09 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: 2803

C207101105

a) Description: Alluminum round billet

b) Ø3.500" x 12.500" long

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Material: 7075-T7351 (QQ-A-225/9)

Material certification required

(40)

2.0	D6103003P	round alum billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)  
 alum billet

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

C207101112

(44)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

BA 07-06-14

(44)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: CVC

BA 07-06-14

(44)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/01/15

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ROUND BILLET, ALUMINUM

Job Number: 30170

Part Number: D6103003

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

48  
07/01/15

Job Completion



W D74015

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

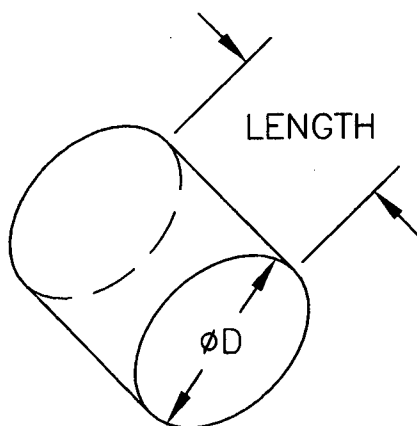
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN D/H	DRAWN BY D/H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H/H	APPROVED H/H	DRAWING NO. D6103	Rev. B SHEET 1 OF 1
DATE 06.01.31		TITLE ROUND BILLET, ALUMINUM	SCALE NTS
A	01.04.10	NEW ISSUE	
B	06.01.31	ADD D6103-003	

## SPECIFICATION CONTROL DRAWING

RELEASED  
06.02.07 H/H



u/o 3070  
n

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

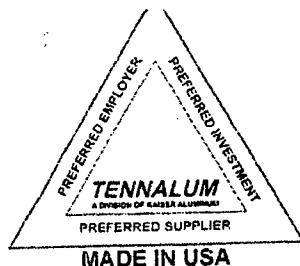
Part No.	Alloy	D (Diameter)	Length
D6103-001	7075-T6/T651 (QQ-A-200/11 OR QQ-A-225/9)	Ø3.250	12.50
D6103-003	7075-T7351 (QQ-A-225/9)	Ø3.500	12.50

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# KAISER ALUMINUM FABRICATED PRODUCTS

Tennalum  
PO Box 669  
Jackson, TN 38302  
731-423-2811



**CERTIFIED TEST REPORT**  
<http://KaiserEngProd.com>

CUSTOMER PO NUMBER: 01-24848		CUSTOMER PART NUMBER: 8808		PRODUCT DESCRIPTION: Cold Finished Round	
KAISER ORDER NUMBER: 622336	LINE ITEM: 1	SHIP DATE: 01/02/2007	ALLOY: 7075	TEMPER: T7351	
WEIGHT SHIPPED: 984 lbs.	QUANTITY: 7 pcs.	B/L NUMBER: 25525	DIAM/DAF/THKNS: 3.500 in.	WIDTH: 0.000 in.	LENGTH: 144.0 in.
SHIP TO:  A M Castle & Co 3400 No. Wolf Road Franklin Park, IL 60131 USA			SOLD TO:  A M Castle & Co 3400 No. Wolf Road Franklin Park, IL 60131 USA		

Test Code: 1000 AC

## Actual Physical Properties

Lot Number	LONG. UTS ksi	LONG. YTS ksi	LONG. ELONG. %	COND % IACS
20085882	70.5	58.6	16.0	38.9
20086295	71.6	60.1	15.0	39.4

## Chemical Composition, WT. % (Aluminum Remainder)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHERS EACH	OTHERS TOTAL	Lot
Actual	0.11	0.28	1.4	0.03	2.7	0.19	5.8	0.02			20085882
Actual	0.12	0.22	1.3	0.02	2.7	0.20	5.8	0.02			20086295
Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15	
Min			1.2		2.1	0.18	5.1				

## Specifications

Standard: ISO 9001, ASTM B211-03, AMS 4124D, AMS-QQ-A-225/9 Non-Standard: A97075-11-9

**CASTLE METALS FP**  
DATE REC'D 1/3/07 IAC 08808  
APPROVED BY: me

## CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

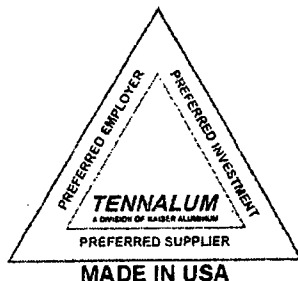
*John Rennekamp*

Plant Serial: 80786

Kaiser Order Number: 622336

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Tennalum  
PO Box 669  
Jackson, TN 38302  
731-423-2811



CERTIFIED TEST REPORT  
<http://KaiserEngProd.com>

## Miscellaneous Notes

Made in USA

This material was melted and manufactured in the USA. Mercury is not a normal contaminant in aluminum alloys. Neither mercury nor any of its compounds were utilized by Kaiser Aluminum in the manufacture of this material. This material meets the requirements of (cold finished) T73 temper and QQ-A-225/9E (CANCELLED). NAFTA - YES.

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Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

Plant Serial: 80786

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